

Work Order ID 81354

81354

Page 1

March-13-12 1:46:40 PM

Item ID: D3535-15

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 13/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/13 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B 2-

Deburr if necessary

304 .040

MLJ/JM 120404 (13)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MLJ/JM 120404 (13)

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

6 12-4-8 (13)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 81354

March-13-12 1:46:40 PM

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Page 2

Item ID: D3535-15 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 13/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-15	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 *150* Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 1:50 FINISH TIME: 2:20	0.00							

M 117338

SB 12/04/09 (13)

(13)

13x

m-k
12/04/10

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March-13-12 1:46:40 PM

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Page 3

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 Start Date: 13/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						13	Ø		12-4-10
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>F-P1</u>	0.00							
170						13x	Ø		M-L 12/04/10
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									12/4/12
QC	Memo	0.00							
Quality Control									

12-04-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-13-12 1:46:44 PM

Page 1

Work Order ID: 81354

81354

Parent Item: D3535-15

D3535-15

Parent Item Name: Wearshoe

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	163.6165	1.0205	12.89053	(13)		

M304S20GA

**

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	163.6165	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	48.6	

121192 →

121192

W/Jm 120404.

(13)

7-12
6789101112

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DART AEROSPACE LTD		Work Order:	81354
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.892	✓		Vern	HB-02
2.000	+/-0.010	2.000	✓		Vern	HB-02
5.650	+/-0.010	5.647	✓		Vern	HB-02
9.150	+/-0.010	9.151	✓		Vern	HB-02
14.400	+/-0.010	14.400	✓		MT	HB-02
19.650	+/-0.010	19.650	✓		MT	HB-01
24.900	+/-0.010	24.900	✓		MT	HB-01
30.150	+/-0.010	30.150	✓		MT	HB-01
33.650	+/-0.010	33.650	✓		MT	HB-01
35.650	+/-0.010	35.650	✓		MT	HB-01
39.150	+/-0.010	39.150	✓		MT	HB-01
Ø0.188	+0.005/-0.001	0.192	✓		Vern	HB-02
24.00	+/-0.030	24.00	✓		MT	HB-01
16.00	+/-0.030	16.00	✓		MT	HB-01
8.00	+/-0.030	8.00	✓		Vern	HB-02
5.00	+/-0.030	5.00	✓		Vern	HB-02
0.300	+/-0.010	0.308	✓		Vern	HB-02
0.300	+/-0.010	0.308	✓		Vern	HB-02
0.038	+/-0.010	0.037	✓		Vern	HB-02

Measured by: <i>MJA/JM</i>	Audited by: <i>SDB</i>	Prototype Approval:	N/A
Date: 120404	Date: 120405	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	<i>[Signature]</i>

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DART

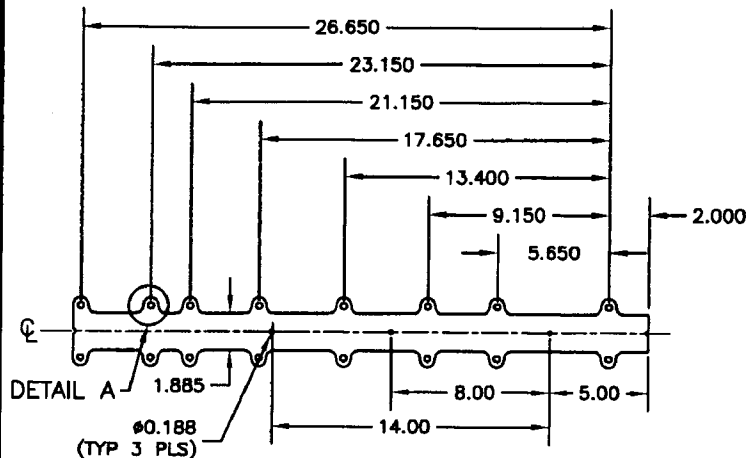
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07.04.24

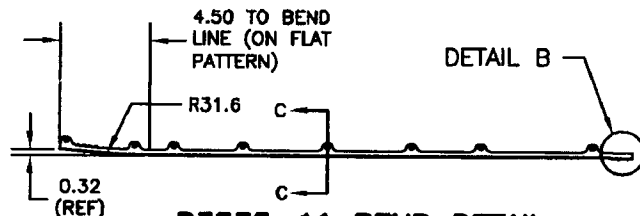
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81354 MCT

12/03/13

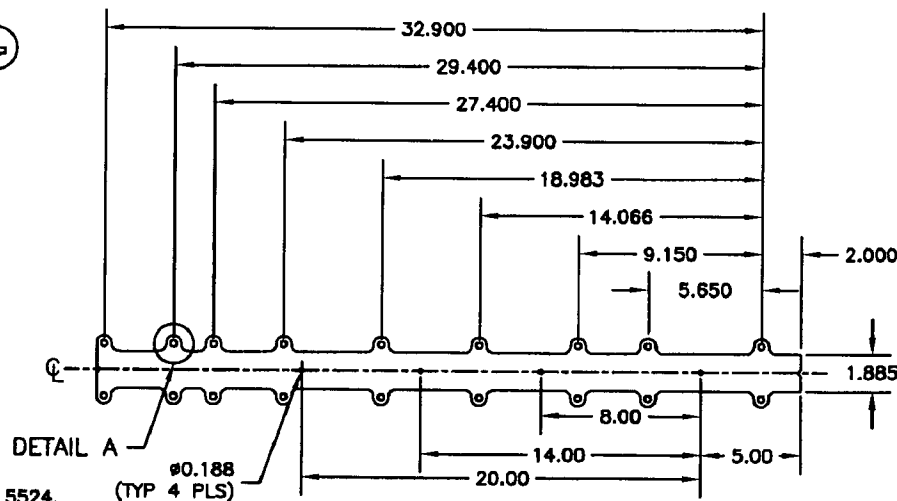
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



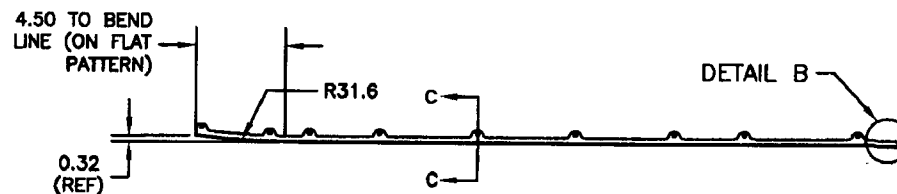
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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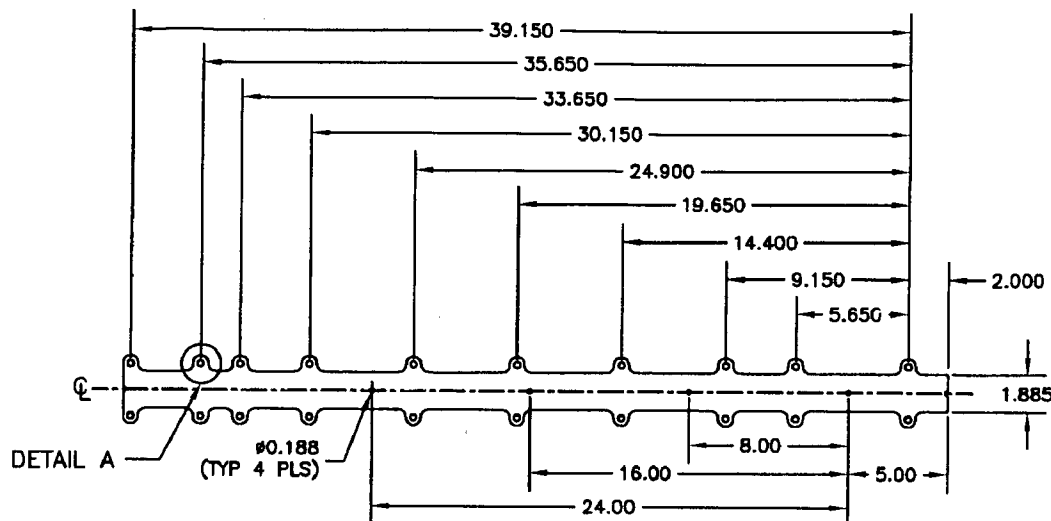
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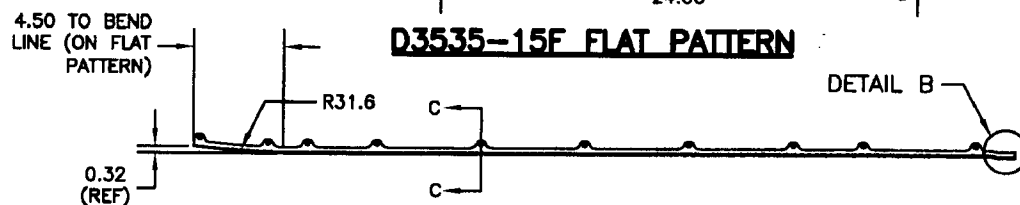
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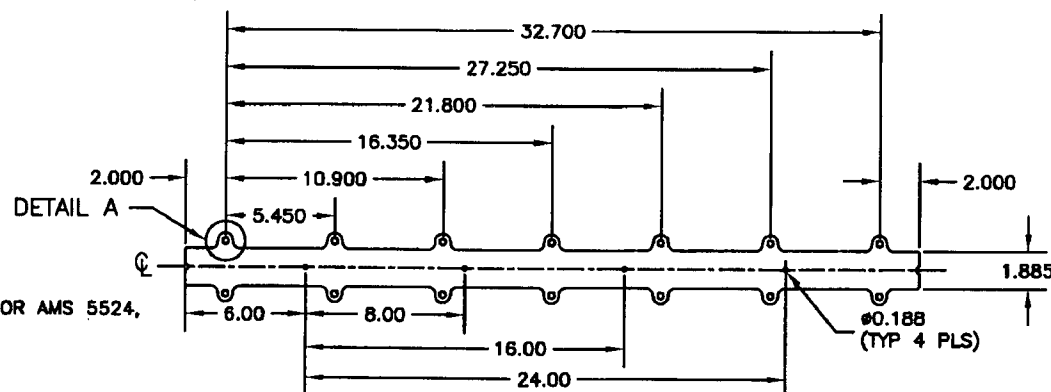
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE 1:10



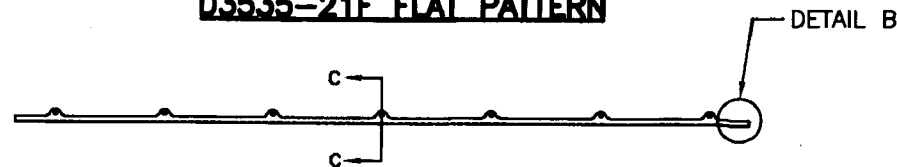
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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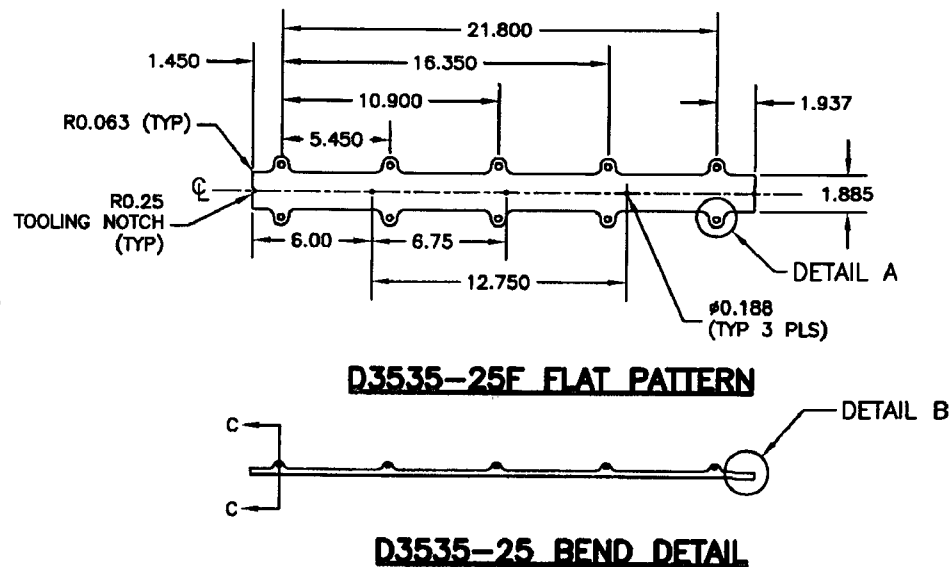
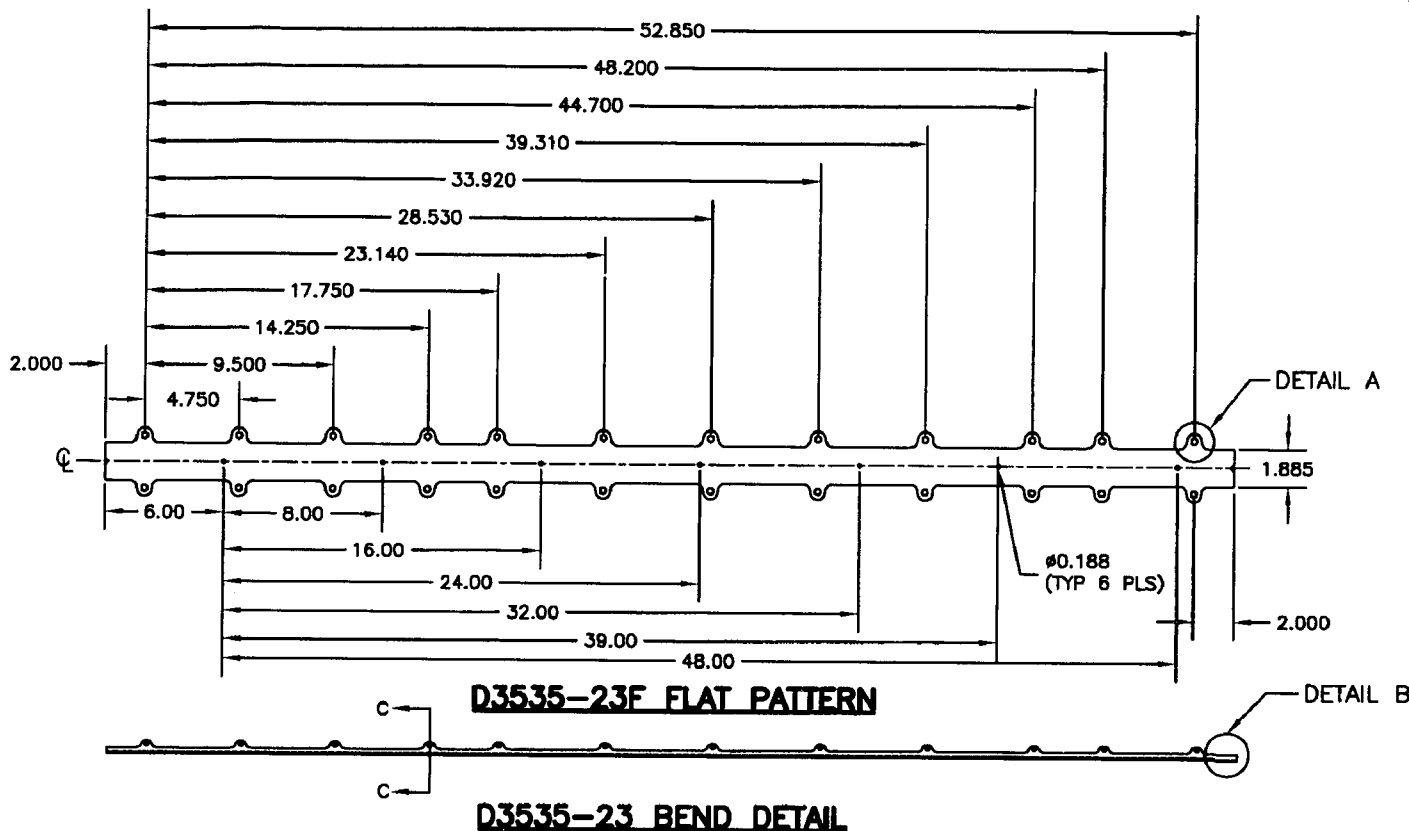
NOTE: Date & initial all entries

DART

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07.04.24

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 3 OF 7
		SCALE 1:10



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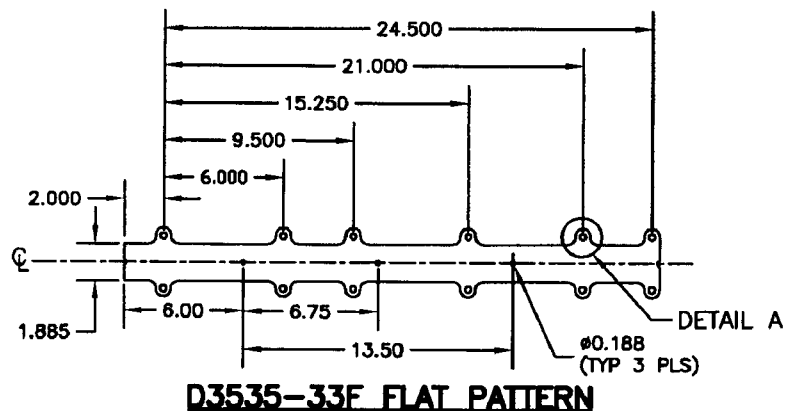
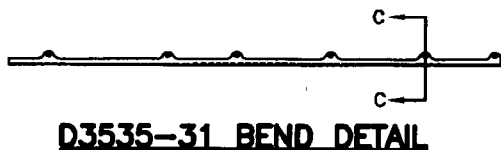
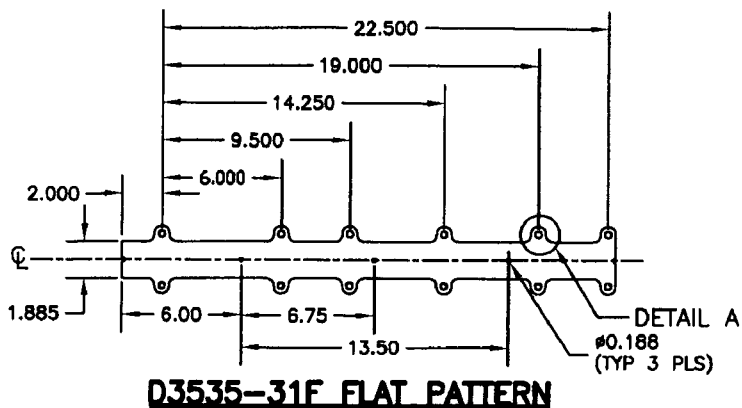
NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	SHEET 4 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	

81354

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07.04.24



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PORT HADLOCK, WA

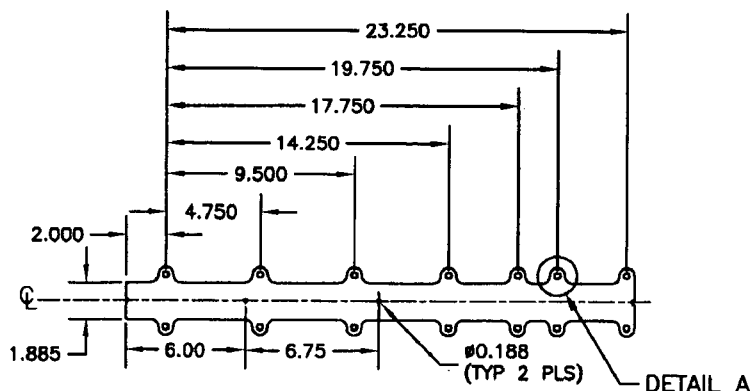
REV. B

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CB	PH	
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	SHEET 5 OF 7
07.04.17	WEARSHOE	

SCALE
1:10

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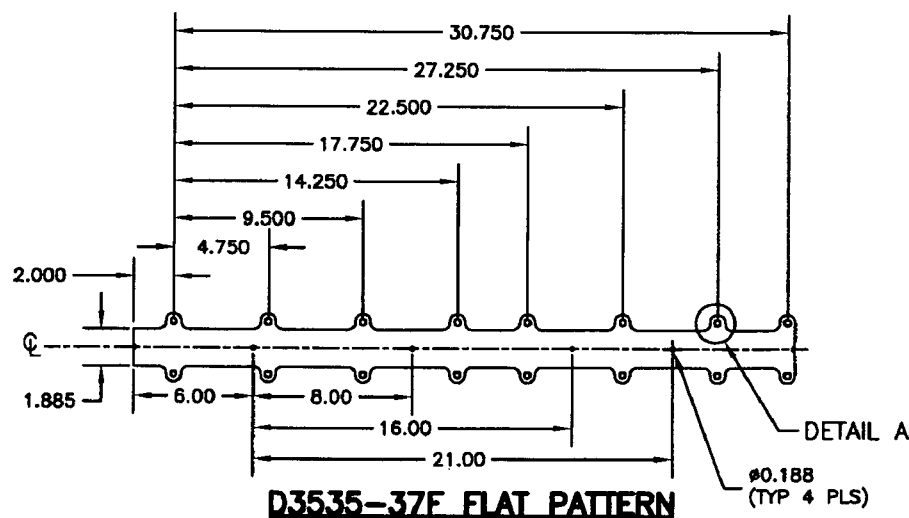
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07.04.24



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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DESIGN BY
CB

DRAWN BY
PH
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKED

APPROVED

DRAWING NO.

DATE

07.04.17

TITLE

WEARSHOE

07.04.17

07.04.17

SCALE

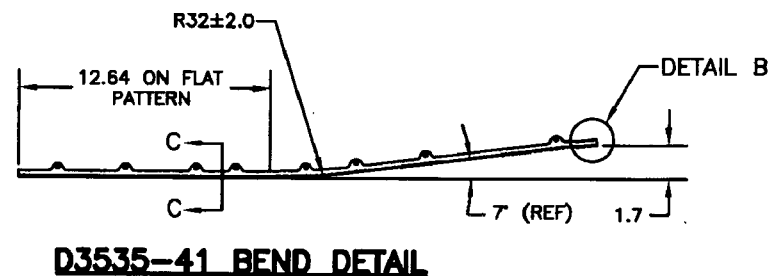
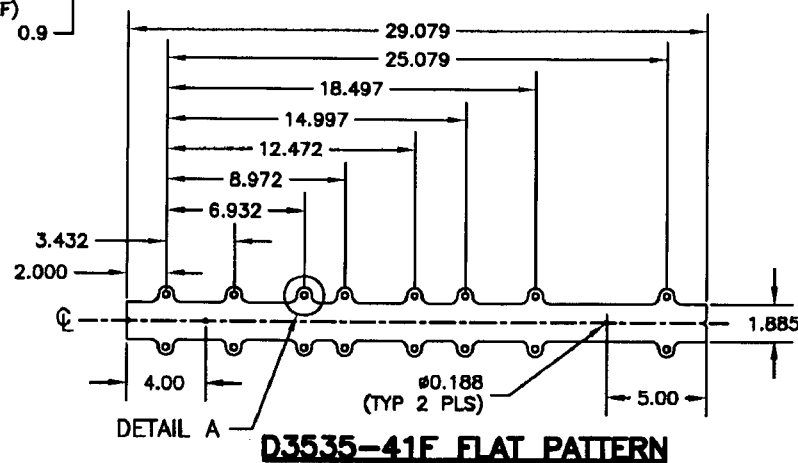
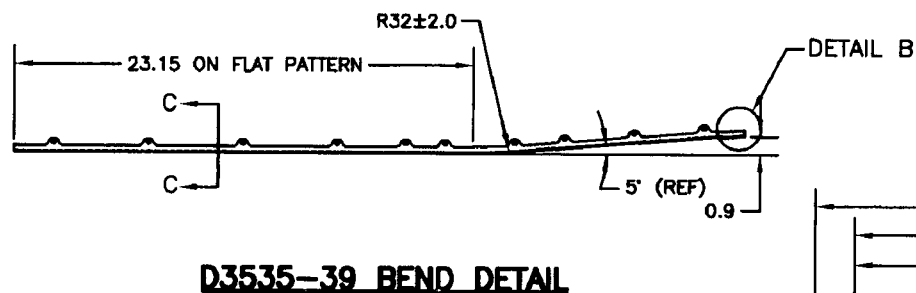
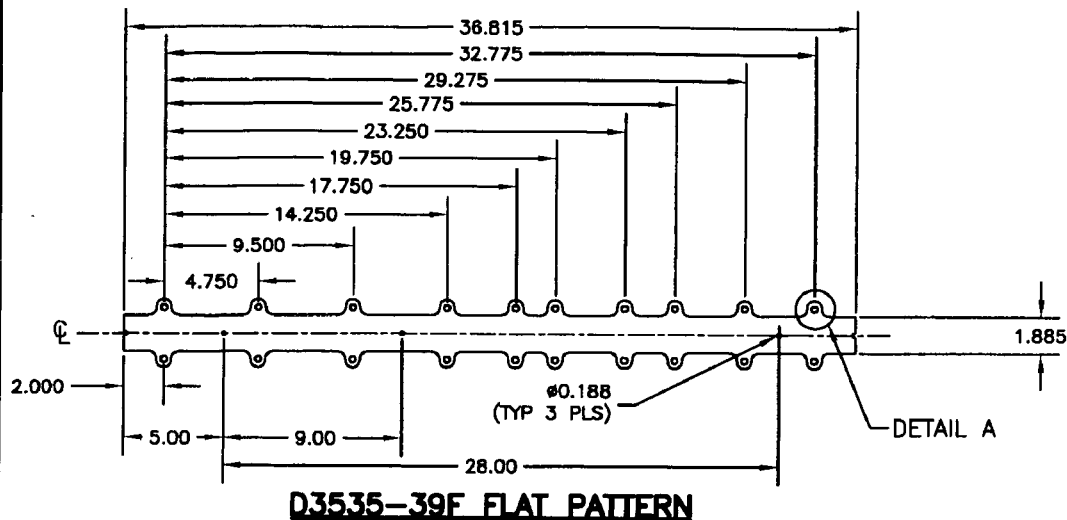
07.04.17

WEARSHOE

1:10

81354

RELEASED
07.04.14



NOTES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries